

Date: Tuesday, 04/11/2008 8:34:14 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: REAR OVERHEAD R/H		
Job Number	: 43180			Part Number	: D38232		
Estimate Number	: 13590			Drawing Number	: D38232 UNDER REVIEW 07.11.08		
P.O. Number	:			Project Number	: IN0002		
This Issue	: 04/11/2008	S.O. No.	:	Drawing Revision	: A UNDER REVIEW		
Prsht Rev.	: NC			Material	: MKYDEX6185S80P362015		
First Issue	: / /	Type	: R&D THERMOFORMING	Due Date	: 14/11/2008	Qty:	2 Um: Each
Previous Run	: 42072						
Written By	:						
Checked & Approved By	:						
Comment	: Est. A New Issue 08/09/17 DL						

PROTOTYPE

PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

07/11/2008 OK

OPENED
~~POSITIVE RECALL~~

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MKYDEX6185S80P362015	Kydex velour matte, ivory
	Comment: Qty.: 11.3747 sf(s)/Unit Total : 22.7493 sf(s) Kydex velour matte, ivory	<i>M 109703</i>
2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
	Comment: HAND FINISHING THERMOFORMING	
	1) Machine set up	<i>08/11/04 W.L.</i>
3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
	Comment: HAND FINISHING THERMOFORMING	<i>(X2)</i>
	1) Cut sheet to required blank size	<i>08/11/04</i>
4.0	THERMOFORMING	THERMOFORMING MACHINE
	Comment: THERMOFORMING MACHINE	<i>(X2)</i>
	Thermoform as per Dwg. D3823-2and folio (FTA 9113 Prototype) using tool DT 9113	
	Dwg. Rev. <u>A</u> UNDER REVIEW. Folio Rev. <u>A</u> .	<i>08/11/04</i>
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>(X2)</i>
	Visually inspect for proper formation of each part	<i>08/11/04</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 04/11/2008 8:34:15 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REAR OVERHEAD R/H

Job Number: 43180

Part Number: D38232

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC8

SECOND CHECK



08.11.26 (2)

(PTC)

Comment: SECOND CHECK

7.0 HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB

08/11/27 (2)

8.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

9.0 QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING
APPROVAL

08.12.01

Comment: INSPECT WORK TO CURRENT STEP

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.12.01 Prototype

Job Completion



08.12.01

POSITIVE RECALL

EFFECTIVE 08.12.01 AUTH.

RELEASED _____

DATE _____

CANCEL
AS

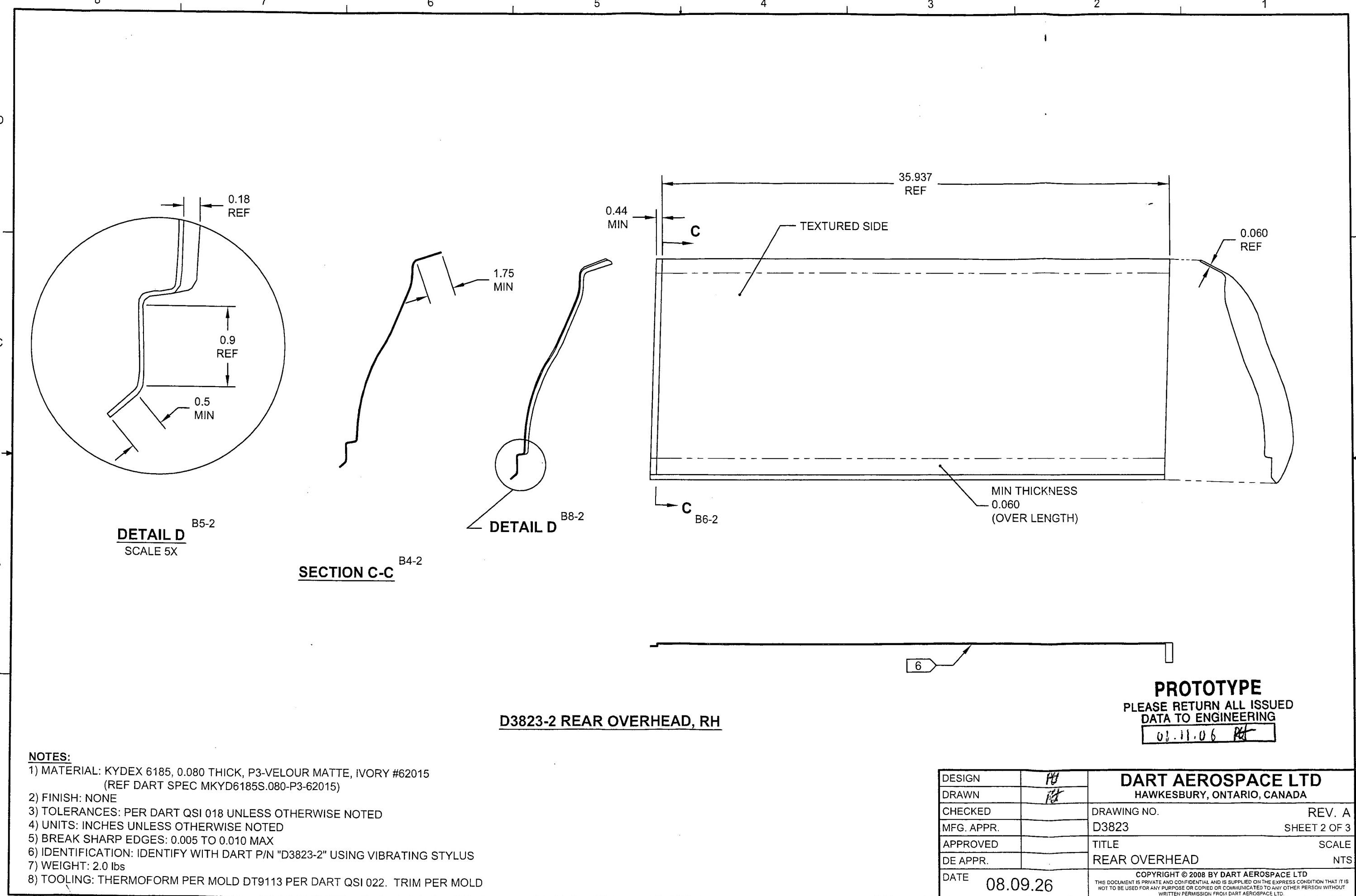
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/11/26	6.0	I part, the 0.9 dim is cut to approximately 0.500" removing the other 0.500" flange.	6S1042	- Part is for testing only and this area is for fasteners. - Should be acceptable for testing.	08/11/26	08/11/26	6S1042	08/11/26
				USE FOR HAT SETUP P.A. 08/12/01				

NOTE: Date & initial all entries



DART AEROSPACE LTD	Work Order:	43181
Description: Rear Overhead RH / Prototype	Part Number:	D3823-2
Inspection Dwg: D3823 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "				
Shape Definition	/			
Texture Retention	/			
Material imperfections such as bumps, cracks, voids, scratching	/			Uncln.

Measured by:

Date:

08.11.04

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.9 (Ref)		0.9	/			
0.5	± 0.100	0.5	/			
1.75"	± 0.030	1.75	/			
0.44	± 0.030	0.44	/			
35.937 (Ref)		35.937	/			This should not be a Ref dim.
0.06 min	min	0.070	/			

Measured by:

Date:

08.11.26

Audited by:

Date:

08.11.26

Prototype Approval:

Date:

08.12.01

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

Receiving Report

Date: 8/10/04Batch No: M109703Supplier: SABRCDart P/O: 7280

Packing Slip: Yes No
Invoice: Yes No
Receipt: Cash Cr

Release Note Attached: Yes No N/A
Waybill Attached: Yes No
Shipment Complete: Yes No N/A
QC6 Inspection: OK N/A
Work Order: OK N/A

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Admin: _____

Location: _____



SABIC Polymershapes

250 OLD INNES RD. 519 OTTAWA, ONT. K1B 5L3
TEL: 613 745 7043 FAX: 613 745 8163

CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE

DATE: 10/3/2008

YOUR PURCHASE ORDER : 7280

OUR SHIPPER NO: 084287

LINE ITEM # :1

QUANTITY: 51

51 *Sab* /27

S
08/027

DESCRIPTION: .080 x 48 x 96 Kydex 6185-P3 IVORY 62015.

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH: FAR 25.853 (a)

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS
OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE
PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND
LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

AUTHORIZED REPRESENTATIVE SIGNATURE

Jon Caldwell

JON CALDWELL
BRANCH MANAGER